

Work Order ID. 77621

\*77621\*

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December-13-11 4:28:10 PM

Item ID: D2739

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: 350 I-Beam

Start Date: 13/12/2011 Start Qty: 4.00

\*4\*

Required Date: 05/01/2012 Req'd Qty: 4.00

\*4\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: M.C.J

Date: 11/12/13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2739

Rev E

100

0.00

\*100\*

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.  
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739  
3-Use uni-bit to open holes to finish size as per Dwg D2739.  
4-Bevel Fwd end of extrusion and Deburr holes and ends.  
5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

\*120\*

HandFinish

Memo

0.00

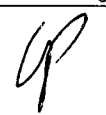
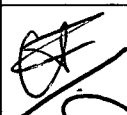

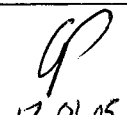
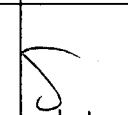
Hand Finishing

(4) 7/12 12 01 05  
Pro →

(4) SAG 1201-05

W/O: 77621		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D 2733 PAR #: \_\_\_\_\_ Fault Category: Leading Edge / Skistubo NCR: (Yes) No DQA: AK Date: 12/1/11  
 Resolution: Acceptable Disposition: Acceptable QA: N/C Closed: ck Date: 12/1/11

NCR: 12-1108		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval • Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/09	# 100	Durbin Frabration employee Moses read the Draw and beveled both ends of the web AS per section Detail B. R.C. new employee / 100	 12.01.09 CS/042	Acceptable this time only Qty x4	 12-1-9	 12/01/10	 12.01.09 CS/042	 12/01/09

NOTE: Date & initial all entries

# Work Order ID: 77621

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**\*77621\***

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Item ID: D2739 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: - Stop **\*NS2\***  
 Item Name: 350 I Beam  
 Start Date: 13/12/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 05/01/2012 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	DP		12-1-9			(4)	
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: 46  Memo	0.00  0.00	DP		12-1-9			(4)	
150 <b>*150*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							12/1/10 ME 12-01-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 77621

\*77621\*

Parent Item: D2739

\*D2739\*

Parent Item Name: 350 I Beam

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 4.00

Required Qty: 4.00

## Comments:

IPP Rev: C02.11.28ReformatKJ

IPP Rev: D 06-03-21 As Per Rev C JLM

IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F

10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108		Manufactured	No			100	Each	244.0000	1	4			

\*D2600-5-108\*

Extrusion 'I Beam' thin

\*\*

## Location

LG

47814

73909

## Loc Qty

244

20

224

## Loc Code

9

6

12-1-1

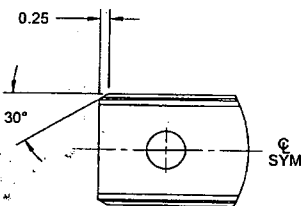
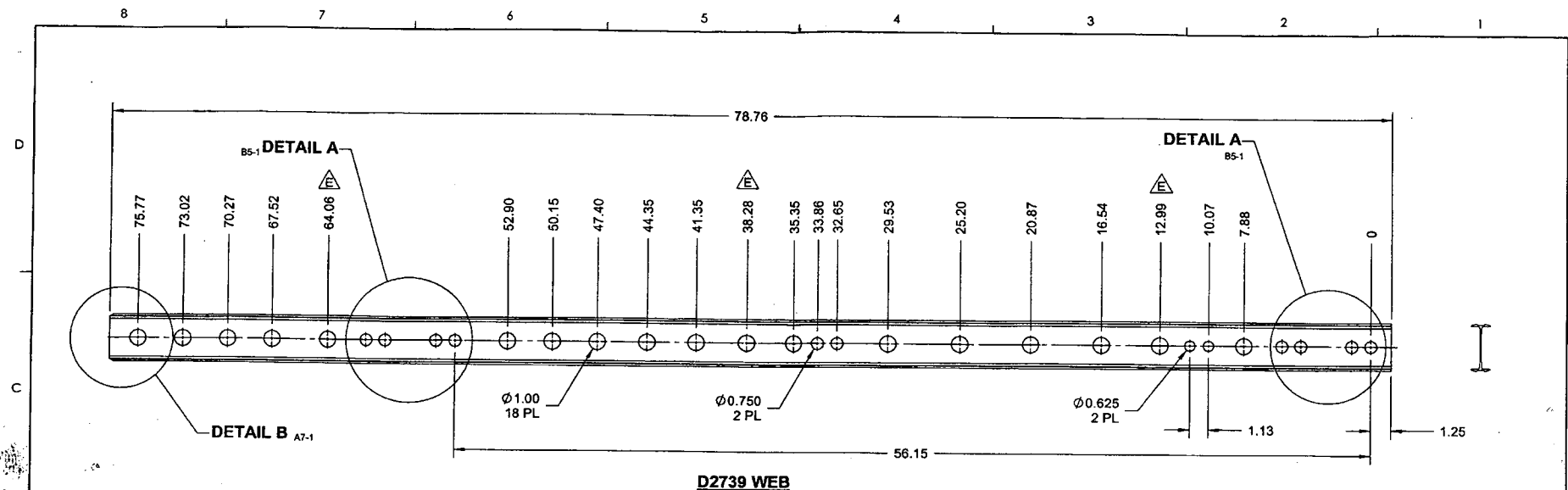
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

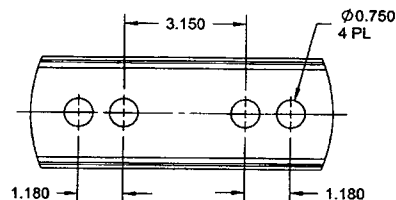
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DETAIL B**  
SCALE 3X C7-1



**DETAIL A**  
SCALE 3X D7-1, D2-1

- NOTES:**
- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: DART P/N "D2739" AND B/N PER DART QSI 044 6.1
  - 7) WEIGHT: 3.41 lbs

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 77621 M.L.J.  
11/12/13

**RELEASED**  
2010-11-01

E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 84.06 WAS 84.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	06.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	JP	DRAWING NO.	REV. E
MFG. APPR.	JP	D2739	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	WEB	NTS
DATE	10.10.08	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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